

What is claimed is:

- Sub 21
1. A flexible isocyanate-based polymeric foam which has:
 - (i) low resiliency;
 - (ii) a T_g less than or equal to about 0°C ; and
 - (iii) a change in $\tan \delta$ less than or equal to about 35% from a median value measured over a temperature range of from about -20° to about $+60^{\circ}\text{C}$.
 2. The isocyanate-based foam defined in claim 1, wherein the T_g is less than about -10°C .
 3. The isocyanate-based foam defined in claim 1, wherein the T_g is in the range of from about -15° to about -40°C .
 4. The isocyanate-based foam defined in claim 1, wherein T_g is in the range of from about -15° to about -37°C .
 5. The isocyanate-based foam defined in claim 1, wherein the T_g is in the range of from about -20° to about -30°C .
 6. The isocyanate-based foam defined in claim 1, wherein the change in $\tan \delta$ is less than or equal to about 20% from a median value.
 7. The isocyanate-based foam defined in claim 1, wherein the change in $\tan \delta$ is in the range of from about 10% to about 15% from a median value.
 8. The isocyanate-based foam defined in claim 1, wherein the change in $\tan \delta$ from the median value is measured over a temperature range of from about -20° to $+80^{\circ}\text{C}$.

9. The isocyanate-based foam defined in claim 1, wherein the change in $\tan \delta$ from the median value is measured over a temperature range of from about -30° to $+100^\circ\text{C}$.

10. The isocyanate-based foam defined in claim 1, wherein the foam is derived from a reaction mixture comprising:

urethane-forming chemicals;

water; and

a plasticizer selected from the group comprising: a halogenated paraffin, a C_2/C_4 aliphatic polymer comprising a primary hydroxyl group, and mixtures thereof.

11. A flexible, low resiliency foam derived from a reaction mixture comprising:

urethane-forming chemicals;

water; and

a plasticizer selected from the group comprising: a halogenated paraffin, a C_2/C_4 aliphatic polymer comprising a primary hydroxyl group, and mixtures thereof.

12. A vehicular interior trim panel comprising the polyurethane foam defined in claim 1.

13. A process for producing an isocyanate-based foam comprising the step contacting the following:

urethane-forming chemicals comprising an isocyanate and an active hydrogen containing compound;

water; and

a plasticizer selected from the group comprising: a halogenated paraffin, a C_2/C_4 aliphatic polymer comprising a primary hydroxyl group, and mixtures thereof.

14. The process defined in claim 13, wherein the halogenated paraffin comprises a chlorinated paraffin.

15. The process defined in claim 13, wherein halogenated paraffin has a molecular weight in the range of from about 300 to about 800.

16. The process defined in claim 13, wherein the halogenated paraffin has a molecular weight in the range of from about 400 to about 700.

17. The process defined in claim 13, wherein halogenated paraffin has a molecular weight in the range of from about 500 to about 550.

18. The process defined in claim 13, wherein the halogenated paraffin has a density in the range of from about 1.2 to about 1.4 g/mL.

19. The process defined in claim 13, wherein the C_2/C_4 aliphatic polymer has an OH equivalent weight in the range of from about 3500 to about 4500.

20. The process defined in claim 13, wherein the C_2/C_4 aliphatic polymer has an OH equivalent weight in the range of from about 3700 to about 3900.

21. The process defined in claim 13, wherein the C_2/C_4 aliphatic polymer has a functionality in the range of from about 0.95 to about 1.00.

22. The process defined in claim 13, wherein the C_2/C_4 aliphatic polymer has a T_g in the range of from about -65° to about 55°C .

23. The process defined in claim 13, wherein the plasticizer is present in an amount of less than about 15 parts by weight, per hundred parts by weight active hydrogen-containing compound.

